

**Work Order ID 53651**

November 11, 2009 3:03:13 PM



Page 1

Item ID: D206-667-203TRN

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Turning Detail

Start Date: 11/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 24/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *09-11-11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D206-667-243

Rev C

100

0.00



Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio  
FA089□2-Turn first side as per Folio FA089□3-File down transition lines  
smooth.*Q.M. 09-11-186*

110

0.00



QC

QC1- Inspect dimensions to dimension sheet

Memo

0.00

Quality Control

*Q.M. 09-11-186*

120

0.00



Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA089□2-File down transition lines smooth.  
□  
3-Remove sand and plugs□4-Scrib part# and batch #*Q.M. 09-11-186*

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC1- Inspect dimensions to dimension sheet	0.00							
QC Quality Control	Memo	0.00				Q.M. 09-11-10-1000			
140 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00				1 - - AWM 9-11-19			
150 	Crosstubes Chemical Conversion	0.00							
HandFXtube Hand Finishing Crosstubes	Memo	0.00				1 - - AWM 9-11-19			

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Page 3

Item ID: D206-667-203TRN

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Turning Detail

Start Date: 11/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 24/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1

9/11/19

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and Stock in kanban rack ☐ Location: X-TUBE CELL

1

-

11/11/19

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/19

11/09-11-19

# Picklist Print

November 11, 2009 3:03:17 PM

Page 1

Work Order ID: 53651

Parent Item: D206-667-203TRNRevC

Parent Item Name: Crosstube Turning Detail

Comments:

Start Date: 11/11/2009

Required Date: 24/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6004-115RevA		Manufactured	No			100	Each	68.0000	1.0000			

Crosstube Material

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	68	
34685	17	
34774	21	
38336	30	

AWM 9-11-16 (1)

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53651
<b>Description:</b> Crosstube Assembly		<b>Part Number:</b>	D206-667-243
<b>Inspection Dwg:</b> D206-667-243 Rev: B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.491	/			
	2.018	+0.005/-0.000	2.023	/			
	2.079	+0.005/-0.000	2.084	/			
	2.145	+0.005/-0.000	2.150	/			
	2.209	+0.005/-0.000	2.214	/			
	2.287	+0.005/-0.000	2.291	/			
	2.363	+0.005/-0.000	2.365	/			
	2.433	+0.005/-0.000	2.438	/			
	0.200	+/-0.010	0.200	/			
	0.500 x 30°	+/-0.010	0.500 x 30°	/			
	R0.063	+/-0.010	R0.063	/			
	R0.500	+/-0.010	R0.500	/			
	4.438	+/-0.030	4.438	/			
SIDE B	104.91	+/-0.020	104.910	/			
	2.490	+0.005/-0.000	2.491	/			
	2.018	+0.005/-0.000	2.023	/			
	2.079	+0.005/-0.000	2.084	/			
	2.145	+0.005/-0.000	2.150	/			
	2.209	+0.005/-0.000	2.214	/			
	2.287	+0.005/-0.000	2.291	/			
	2.363	+0.005/-0.000	2.365	/			
	2.433	+0.005/-0.000	2.438	/			
	0.200	+/-0.010	0.200	/			
	0.500 x 30°	+/-0.010	0.500 x 30°	/			
	R0.063	+/-0.010	R0.063	/			
	R0.500	+/-0.010	R0.500	/			
	4.438	+/-0.030	4.438	/			

<b>Measured by:</b>	a.m	<b>Audited by:</b>	A.M	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	09.11.13	<b>Date:</b>	9-11-09	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	

Item	Qty	Part Number	Description
	-243		
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

#### GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON  
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,  
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE  
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER  
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE  
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE  
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 53601  
09-11-11

RELEASED  
8/11/11

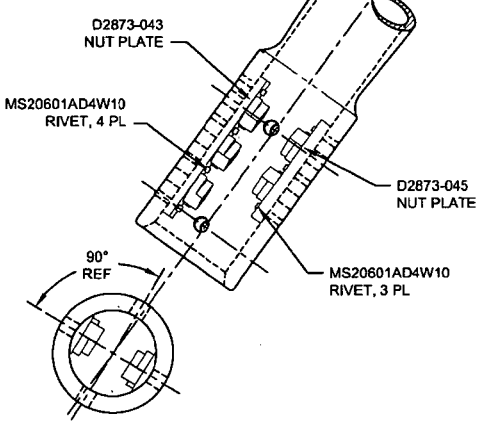
C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-243	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.11.06		

w/o 53651

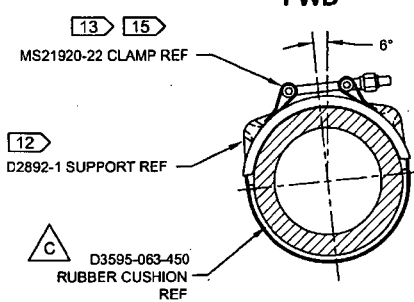
RELEASED

- 12 D2892-1 SUPPORT  
2 PL
- 15 MS21920-22 CLAMP  
4 PL
- 13 D3595-063-450  
RUBBER CUSHION  
4 PL, (UNDER CLAMP)

**D206-667-243**  
**ASSEMBLY DETAIL**  
(VIEW LOOKING FWD)



**VIEW A-A:**  
**CUFF DETAIL**  
SCALE 4X

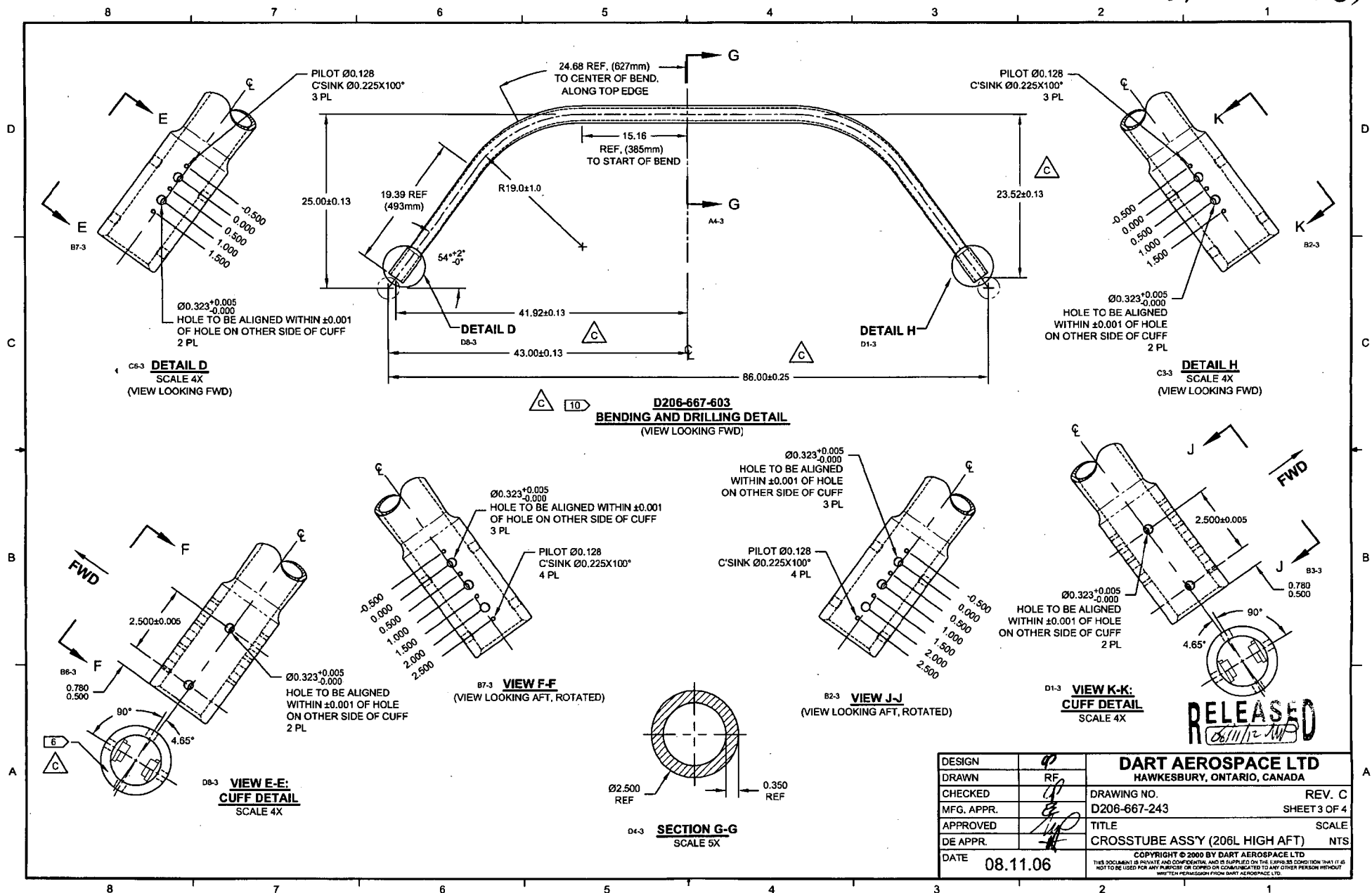


**SECTION B-B**  
SCALE 5X

**VIEW C-C:**  
**CUFF DETAIL**  
SCALE 4X

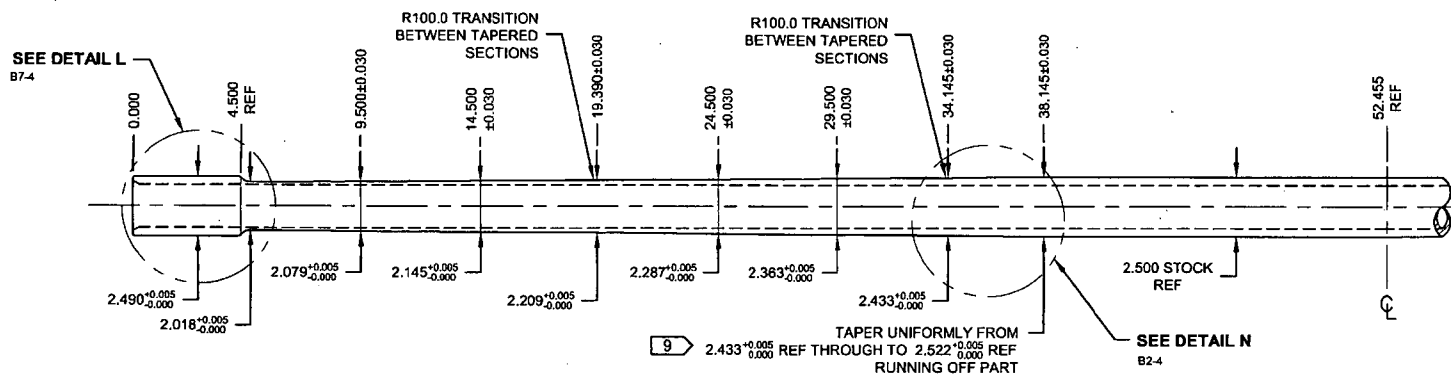
DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	EP	D206-667-243	SHEET 2 OF 4
APPROVED	EP	TITLE	SCALE
DE APPR.	EP	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
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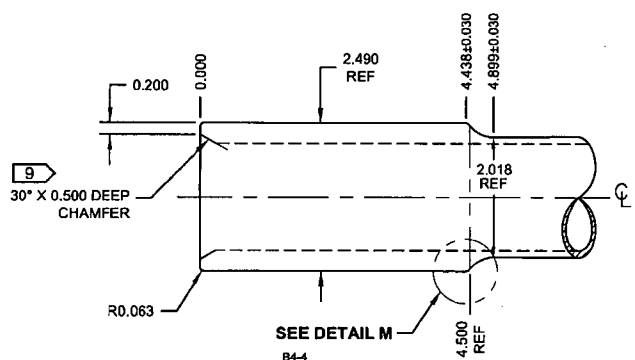




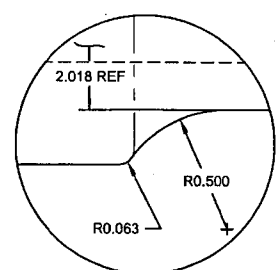
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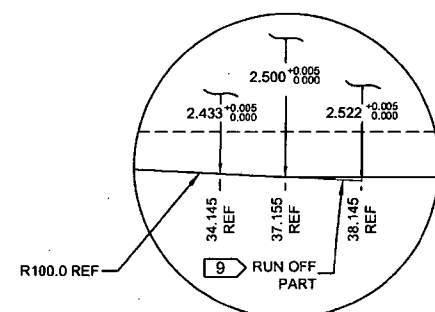
**C TURNING DETAIL**



**C7-4 DETAIL L: CROSSTUBE CUFF**  
NOT TO SCALE



**B6-4 DETAIL M: CUFF TRANSITION**  
NOT TO SCALE



**DETAIL N: TAPER RUN-OFF**  
NOT TO SCALE

**RELEASED**  
08/11/2006

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-243	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
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